

Date: Tuesday, 7/1/2008 10:47:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ACCESS PANEL ASSEMBLY		
Job Number	: 40165					
Estimate Number	: 13039					
P.O. Number	:			Part Number	: D32561	
This Issue	: 7/1/2008		S.O. No.	: D3256 REV C		
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 36632			Drawing Revision	: C	
Written By	:			Material	:	
Checked & Approved By	:			Due Date	: 7/28/2008	
Comment	: Est Rev:A New Issue 07-09-28 EC verified by:DD			Qty:	4 Um: Each	
	Est Rev:b ECN 1052 07-10-31 DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S22GA	304/316 .032 Sheet	
		Comment: Qty.: 0.9870 sf(s)/Unit Total : 3.9480 sf(s) 304/316 .032 Sheet Batch: 109023	
		1B 8-8-25 MAT NOT PULLED	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3256	
		Dwg Rev: C Prog Rev: C	
		RB 8-8-25	(S)
		2-Deburr if necessary	RB 8-8-25
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		RB 8-8-25	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		S 08/08/08 (78)	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		FF 08/08/26 (5)	
		Comment: NC BRAKE -Form using D3256-1T2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 10:47:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 40165

Part Number: D32561

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



8/08/08/27x5

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify with part# and batch# with fine point ink marker and Stack

Location: 181

8/8/27

SP

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/27 SP

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



8/08/08/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

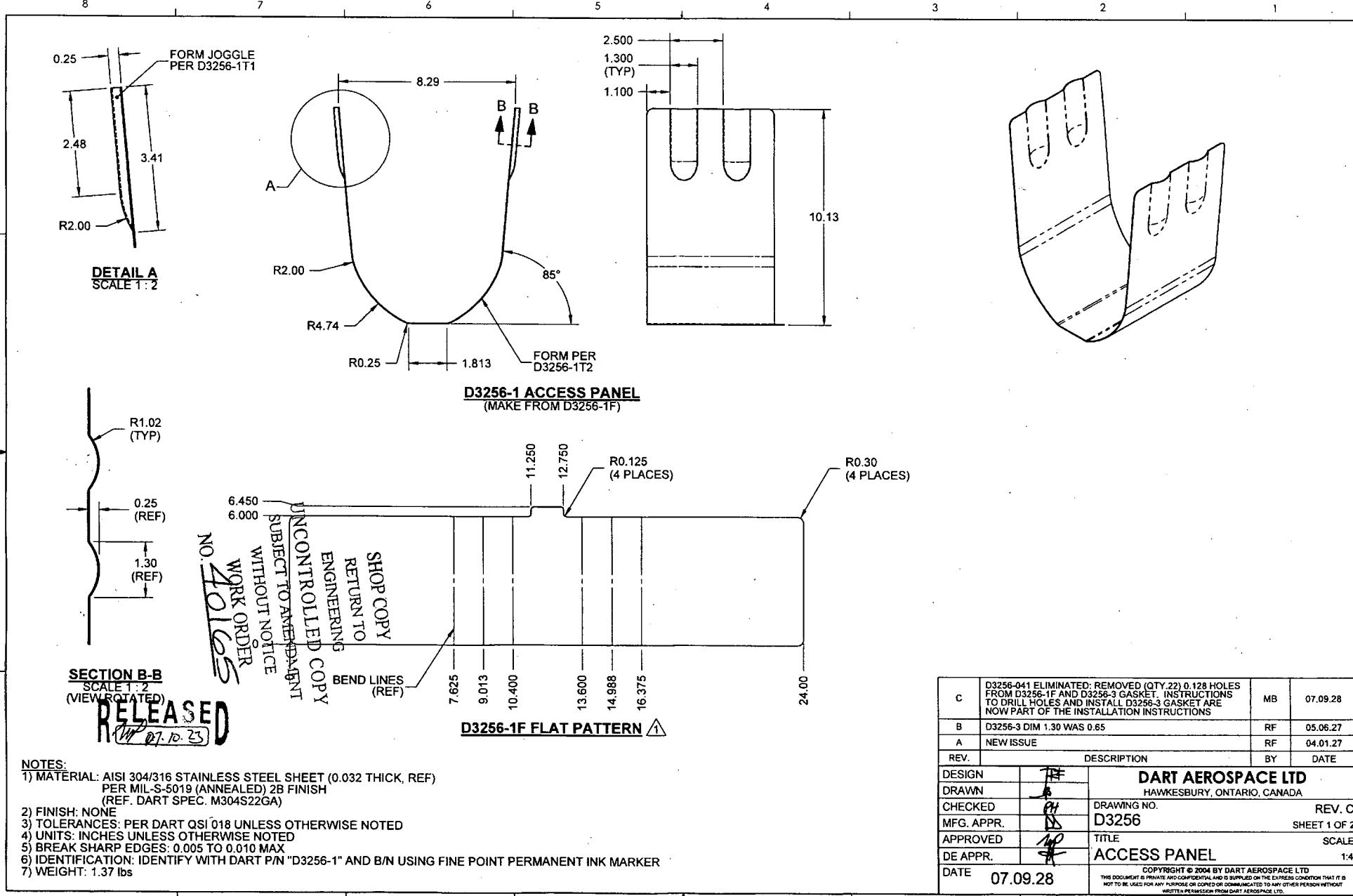
DART AEROSPACE LTD	Work Order:	40165
Description: Access Panel Assembly	Part Number:	D3256-1
Inspection Dwg: D3256 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

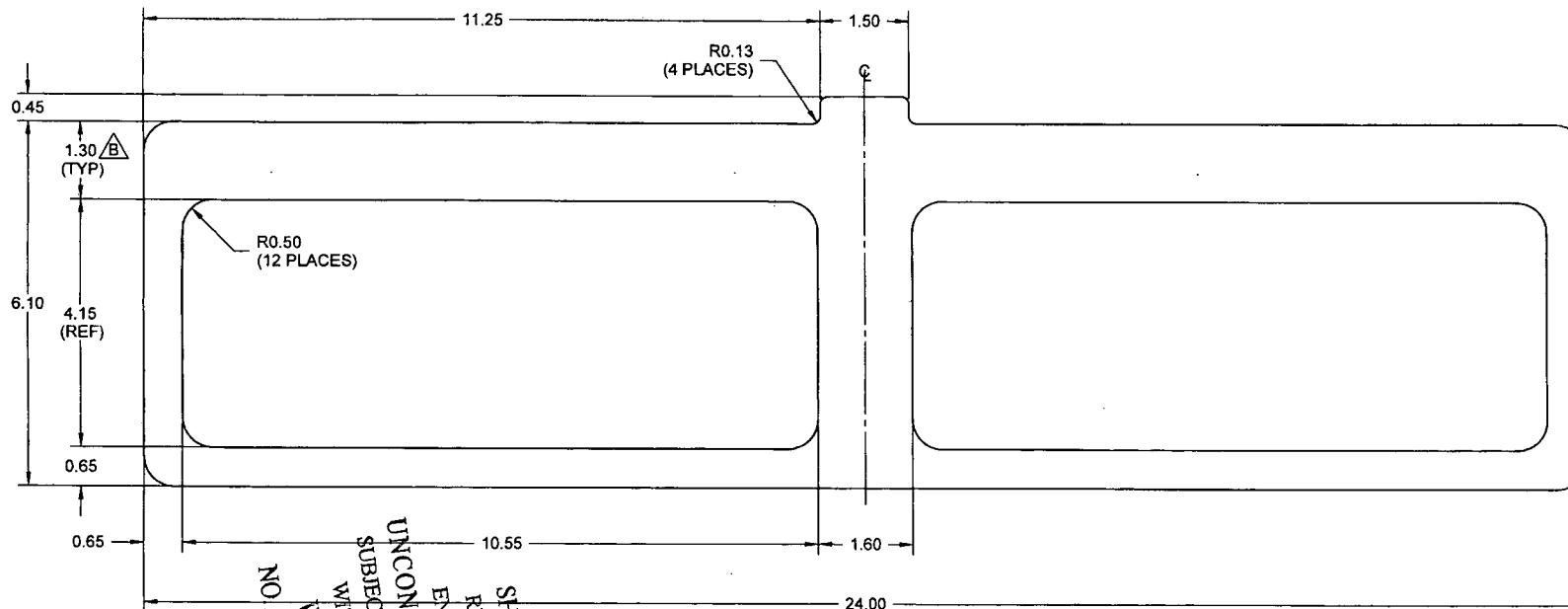
X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	8-8-25	Date:	08/08/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3256-041	KJ/JLM	SJF



8 7 6 5 4 3 2 1

D3256-3 ACCESS PANELRELEASED
07-10-03

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NO WORK ORDER
WITHOUT NOTICE
40165

SHOP COPY
RETURN TO
ENGINEERING

NOTES:

- 1) MATERIËL: DURABLA BLACK GASKET 0.035 THICK PER MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2)
OR MIL-G-12803A (GRADE P-1161A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<u>JF</u>	DART AEROSPACE LTD	
DRAWN	<u>JB</u>	HAWKSBURY, ONTARIO, CANADA	
CHECKED	<u>PH</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>DS</u>	D3256	SHEET 2 OF 2
APPROVED	<u>MB</u>	TITLE	SCALE
DE APPR.	<u>MB</u>	ACCESS PANEL	12
DATE	07.09.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1